

Work Order ID 93956

Wednesday, November 28, 2012 8:45:14 AM

93956

Page 1

Item ID: D4410-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Co-Pilot Collective Head Assembly (212)

Start Date: 11/28/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/7/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MVC*

Date: 12-11-28

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4410-

REV B

100

Manufacture as per dwg

0.00

100

Mill Conv

Memo

0.00

Conventional Milling Machine

ON D4410-1, RE-DRILL & REAM AS PER D4410-043, NOTE #9

USE DT9777B COMPOUND ANGLE BLOCK

101

QC5- Inspect part completeness to step on W/O

0.00

101

QC

Memo

0.00

Quality Control

110

Weld per dwg A/R Aluminum rod Batch: *M120859****110***

Large Fab

Memo

0.00

Large Fab

WELD D4410-7, D4410-1 & D4410-15 AS PER DWG

GRIND WELD FLUSH WHERE INDICATED AS PER DWG.

*12-11-28***DAS**
15
9-89*121128**EL 1211-29*

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Start Date: 11/28/2012 Start Qty: 1.00

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Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds ✓

0.00

120

QC

Memo

0.00

Quality Control

12-11-30

DAS
09
8-89

130

QC5- Inspect part completeness to step on W/O ✓

0.00

130

QC

Memo

0.00

Quality Control

12-11-30

DAS
09
8-89

140

Outsource process-Anodize per QSI017 4.1.10.1

0.00

140

Outsource4

Memo

0.00

Outsource process - Anodize

Issue P/O: 18584
Black Anodize as per Dwg D4410

12-11-12

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Item ID: D4410-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Co-Pilot Collective Head Assembly (212)

Start Date: 11/28/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/7/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

| Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---------|--------|-----------|------------|------------|---------------|-------------|
|---------|--------|-----------|------------|------------|---------------|-------------|

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Memo

0.00

Packaging

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

170

170

Small Fab

Memo

0.00

Small Fab

ASSEMBLE AS PER DWG,
RE-PASS HELICOIL TAP IN THREADS

A/R: PROSEAL 890 OR EQUIVALENT

Insert pin thru 1 side only

BATCH #: 129028

1 PF 13-02-19

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Item ID: D4410-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Co-Pilot Collective Head Assembly (212)

Start Date: 11/28/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/7/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location: ST 198 0.00***190***

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release 0.00

200

QC

Memo

0.00

Quality Control

ML5 13-02-21

11/13/02-21

Picklist Print

Wednesday, November 28, 2012 8:45:14 A

Page 1

Work Order ID: 93956

Parent Item: D4410-043

Parent Item Name: Co-Pilot Collective Head Assembly (212)

Start Date: 11/28/2012

Required Date: 12/7/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP REV:A NEW ISSUE 11-11-02 JLM VERIFIED BY:DD
12/08/10 JFS VERIFIED BY:JLM IPP REV:C AS PER REV:PB10 12/09/20 JFS VERIFIED BY:DD

IPP REV:B AS PER REV:PB6

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|-------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D4410-1 Co-Pilot Collective Head | | Manufactured | No | | 91385 | 100 | Each | 10.0000 | 1 | 1 | | 12-7-29 | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST107 | 4 | |
| 92434 | 4 | |
| WA | 6 | |
| 91385 | 6 | |

D4410-7
Conduit

| | | | | | | | | |
|--------------|----|--|-----|------|--------|---|---|----------|
| Manufactured | No | | 110 | Each | 6.0000 | 1 | 1 | 12-11-29 |
|--------------|----|--|-----|------|--------|---|---|----------|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA | 6 | |
| 91386 | 6 | |

D4410-13
Shim (212)

| | | | | | | | | |
|--------------|----|--|-----|------|--------|---|---|-------------|
| Manufactured | No | | 170 | Each | 1.0000 | 1 | 1 | FF 13-02-19 |
|--------------|----|--|-----|------|--------|---|---|-------------|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ENG | 1 | |
| 88987 | 1 | |

D4410-15
Rear Cover

| | | | | | | | | |
|--------------|----|--|-----|------|---------|---|---|----------|
| Manufactured | No | | 110 | Each | 12.0000 | 1 | 1 | 12-11-29 |
|--------------|----|--|-----|------|---------|---|---|----------|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST107 | 12 | |
| 90611 | 1 | |
| 91384 | 11 | |

D4413-1
Dome Plug

| | | | | | | | | |
|--------------|----|--|-----|------|----------|---|---|--|
| Manufactured | No | | 170 | Each | 100.0000 | 1 | 1 | |
|--------------|----|--|-----|------|----------|---|---|--|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST107 | 100 | |
| 80844 | 5 | |
| 91375 | 95 | |

FF 13-01-14

Picklist Print

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Page 2

Work Order ID: 93956

Parent Item: D4410-043

Parent Item Name: Co-Pilot Collective Head Assembly (212)

Start Date: 11/28/2012

Required Date: 12/7/2012

Start Qty: 1.00

Required Qty: 1.00

90296A108

Purchased

No

170

Each

101.0000

4

4

Heli-Coil Insert

FF 13-01-14

Location

Loc Qty

Loc Code

cnc

7

120040

3

123120

4

GA

94

123496

94

MS171599

Purchased

No

170

Each

26.0000

1

1

Pin

FF 13-01-14

Location

Loc Qty

Loc Code

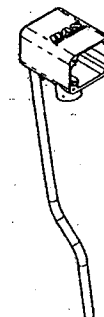
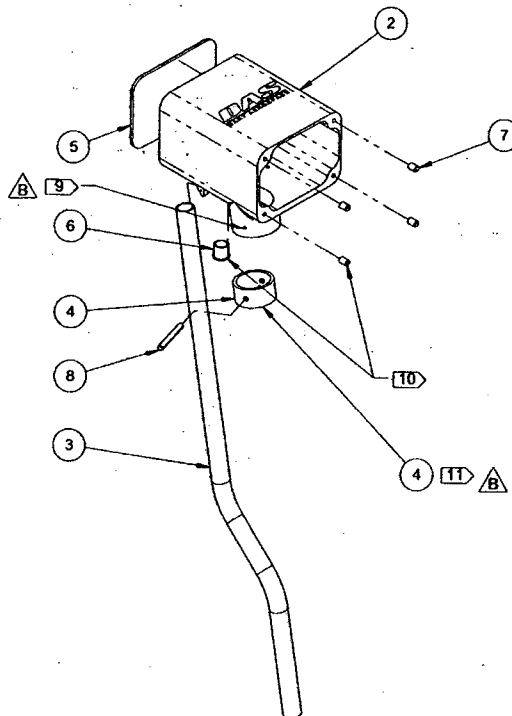
ST331

26

123183

26

| ITEM NO. | QTY. -043 | PART NUMBER | DESCRIPTION |
|----------|--------------|-------------|---|
| 1 | X | D4410-043 | CO-PILOT COLLECTIVE HEAD ASSEMBLY (212) |
| 2 | 1 | D4410-1 | CO-PILOT COLLECTIVE HEAD |
| 3 | 1 | D4410-7 | CONDUIT |
| 4 | 1 | D4410-13 | 212 SHIM |
| 5 | 1 | D4410-15 | REAR COVER |
| 6 | 1 | D4413-1 | DOME PLUG |
| 7 | 4 | 90296A108 | HELI-COIL INSERT (6-32 X 0.276) |
| 8 | 1 | MS171599 | PIN |



93956

RELEASE
2012-09-28
WPL

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.55 lbs
- 8) WELD PER DART QSI 004
- 9) REAM TO Ø0.177 (DRILL #16)
- 10) INSTALL AFTER ANODIZING
- 11) INSTALL AFTER ANODIZING WET WITH PROSEAL 890 OR EQUIVALENT ENSURE THAT PROSEAL DOES NOT CONTACT PIN

D4410-043 CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)

| | | | |
|------------|----------|---|---------------|
| DESIGN | DL | DART AEROSPACE USA, INC. | |
| DRAWN | DL | KENT, WA | |
| CHECKED | DL | DRAWING NO. | REV. B |
| MFG. APPR. | DL | D4410 | SHEET 2 OF 12 |
| APPROVED | DL | TITLE | SCALE |
| DE APPR. | DL | CO-PILOT COLLECTIVE HEAD | NTS |
| DATE | 12.07.30 | COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62102

Date: 11-Dec-12

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

| Terms | Ship Via |
|-------|----------|
| | |

| Quantity | Description |
|----------|---|
| 1 lot | Part: ASST Rev: 4 PCS D4703-043 4 PCS D4726-1 1 PC D4410-043 → <i>8 rchz12</i> 5 PCS D4410-041 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120762 PO: PO18584 Line: |

Certificate of Conformance

A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.

ISO 9001 : 2008 REGISTERED
ATG SALES-2010 TERMS APPLY

DATE: 11/12/12

CERTIFIED SIGNATURE: *mw*

RECEIVER SIGNATURE: _____



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO18584**

Purchase Order Date 12/05/12

PO Print Date 12/11/12

Page Number 1 of 2

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

613-446-4544

613-446-4556

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Brigitte Golden

10127-2607

Net 30

CAD

Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

| Line Nbr | Reference Revision ID Vendor Part Number | Description/ Mfg ID | Req Date/ Taxable | Req Qty/ Unit of Measure | Ship Method | Unit Price | Extended Price |
|----------|--|-------------------------------|--|-----------------------------|------------------|------------|-------------------|
| 1 | 92153 | D4703-043 Lock Pin | 12/21/12 Yes | 4.00 | Purolator ground | \$10.7143 | \$42.86 |
| | | Special Inst: | FINISH: BLACK ANODIZE PER MIL-8625F, TYPE III, CALSS 2 | | | | |
| 2 | 92205 | D4726-1 Handle | 12/21/12 Yes | 4.00 | Purolator ground | \$10.7143 | \$42.86 |
| | | Special Inst: | Same as Above | | | | |
| 3 | 93956 | D4410-043 Co-Pilot Head Ass'y | 12/21/12 Yes | 1.00 | Purolator ground | \$10.7143 | \$10.71 |
| | | Special Inst: | Same as Above | | | | |
| 4 | 91379 | D4410-041 Co-Pilot Head Ass'y | 12/21/12 Yes | 5.00 | Purolator ground | \$10.7143 | \$53.57 |

**CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY**

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required - YES NO

Change Nbr:

2

Change Date: 12/11/12